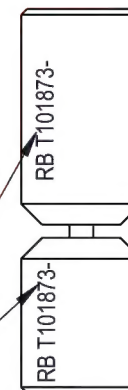
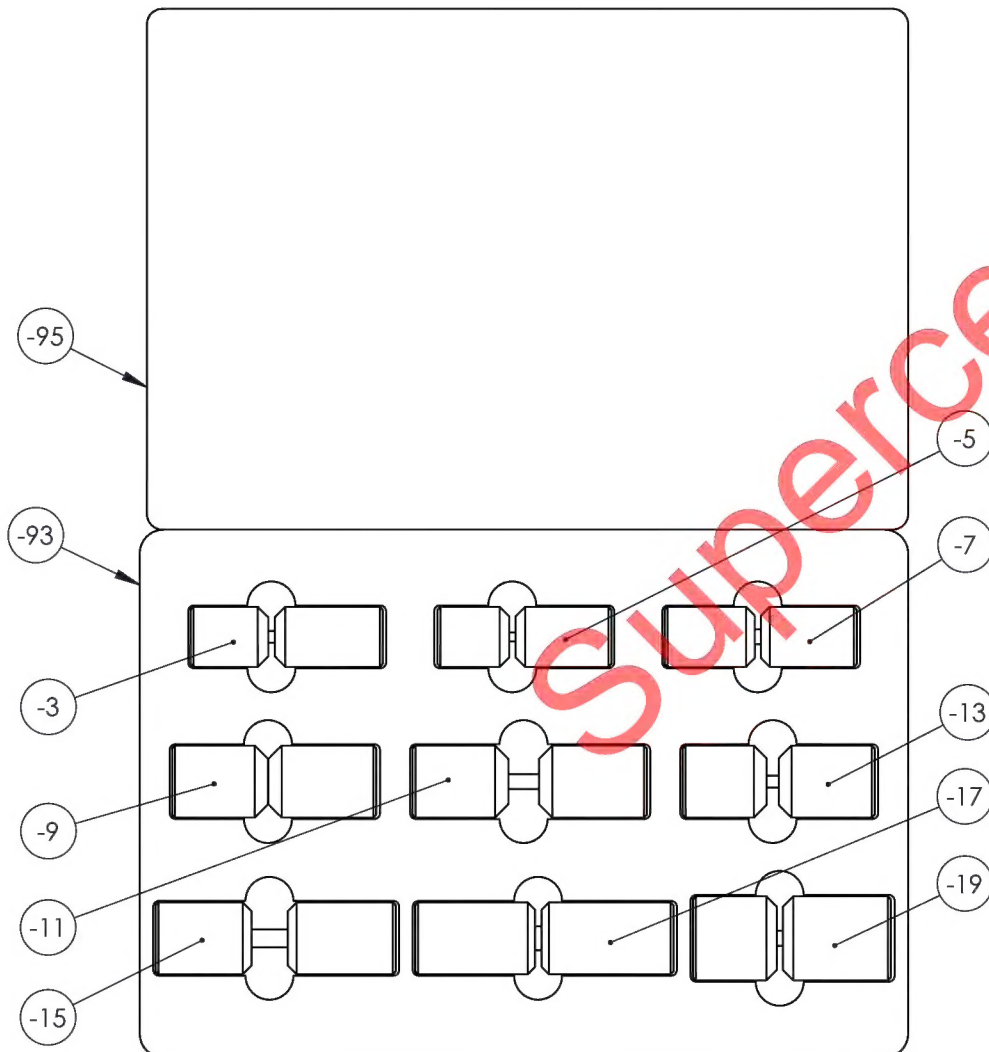


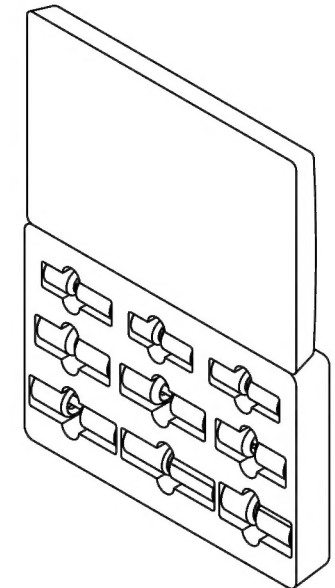
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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
A		UPDATED DRAFTING STANDARD	5/8/12		
B		<del>-39, -45, -51, -57, -63, -69, -75, -81, -87</del> ADDED REFERENCE COLUMN K TO TABLE, ADDED DRILL POINT TO HOLE. <del>-43, -49, -55, -61, -67, -73, -79, -85, -91</del> CH'D TOLERANCE WAS D ±.03 IS D MIN., ADDED REFERENCE COLUMN K TO TABLE, ADDED DRILL POINT TO HOLE.	9/3/13	CFS	JG
1	14-0210	SHEET 3 ADDED DATUM C AND D, ADDED GEOMETRIC TOLERANCE .005 D AND .005 C, DELETED NOTE 2. SHEET 4 ADDED DATUM C AND E, ADDED GEOMETRIC TOLERANCE .005 E AND .005 C, DELETED NOTE 2. <del>-93, -95</del> CH'D FOAM WAS FOR MAPLE BOX IS FOR PELICAN CASE #1470. CH'D FOAM WAS GRAY CHARCOAL PLANK IS Y20 BLACK. <del>-96</del> ADDED TAPE. <del>-97</del> DELETED 4X Ø.15 HOLES IN CORNERS, CH'D SIZE TO FIT PELICAN CASE. <del>-98</del> ADDED PELICAN CASE #1470. <del>-99</del> DELETED.	11/6/2014	RJC	JAG

**UNDER REVIEW**  
URF 19-691 19.04.18 (MB)



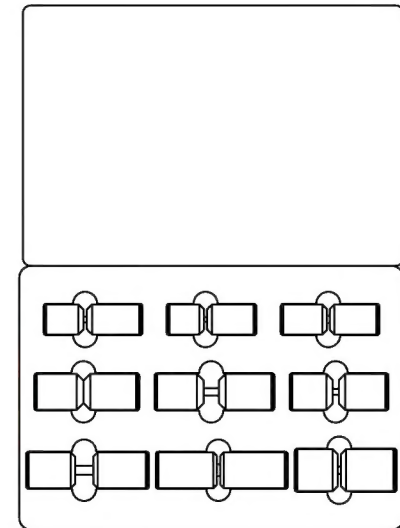
ENGRAVE PART NO. WITH APPLICABLE  
ASSY. DASH NO. AS SHOWN



<b>DART AEROSPACE</b>	
TITLE <b>RING STAKE TOOL</b>	
DWG NO. <b>RB T101873</b>	REV <b>1</b>
MAT'L <b>UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± 5° .X ± .1</b>	DRAWN BY: <b>GILBERT</b> APPROVED <i>D Weil</i> HEAT TREAT FINISH SPEC
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE <b>1:2</b>	DATE <b>5/7/2012</b>
SHEET 1 OF 8	

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ASSY QTY	ASSY QTY	ASSY QTY	ASSY QTY	ASSY QTY	ASSY QTY	ASSY QTY	ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
								X		-3	1	3 ASSY			1
								1		-39		PRESS	O1		3
								1		-41		GUIDE	STD HARDENED DOWEL	Ø.2480 X 3 VERMONT PRECISION TOOLS #651214110 (MODIFIED)	5
								1		-43		BASE	O1		4
							X			-5	1	5 ASSY			1
							1			-45		PRESS	O1		3
							1			-47		GUIDE	STD HARDENED DOWEL	Ø.1880 X 2.62 VERMONT PRECISION TOOLS #651212110 (MODIFIED)	5
							1			-49		BASE	O1		4
						X				-7	1	7 ASSY			1
						1				-51		PRESS	O1		3
						1				-53		GUIDE	STD HARDENED DOWEL	Ø.3105 X 3 VERMONT PRECISION TOOLS #651218110 (MODIFIED)	5
						1				-55		BASE	O1		4
					X					-9	1	9 ASSY			1
					1					-57		PRESS	O1		3
					1					-59		GUIDE	STD HARDENED DOWEL	Ø.3730 X 3.25 VERMONT PRECISION TOOLS #651222110 (MODIFIED)	5
					1					-61		BASE	O1		4
				X						-11	1	11 ASSY			1
				1						-63		PRESS	O1		3
				1						-65		GUIDE	STD HARDENED DOWEL	Ø.3105 X 3.88 VERMONT PRECISION TOOLS #651218110 (MODIFIED)	5
				1						-67		BASE	O1		4
			X							-13	1	13 ASSY			1
			1							-69		PRESS	O1		3
			1							-71		GUIDE	STD HARDENED DOWEL	Ø.2480 X 3 VERMONT PRECISION TOOLS #651214110 (MODIFIED)	5
			1							-73		BASE	O1		4
		X								-15	1	15 ASSY			1
		1								-75		PRESS	O1		3
		1								-77		GUIDE	STD HARDENED DOWEL	Ø.3730 X 4 VERMONT PRECISION TOOLS #651222110 (MODIFIED)	5
		1								-79		BASE	O1		4
X										-17	1	17 ASSY			1
1										-81		PRESS	O1		3
										-83		GUIDE	STD HARDENED DOWEL	Ø.4980 X 4.38 VERMONT PRECISION TOOLS #651230110 (MODIFIED)	5
										-85		BASE	O1		4
X										-19	1	19 ASSY			1
1										-87		PRESS	O1		3
1										-89		GUIDE	STD HARDENED DOWEL	Ø.3105 X 3.12 VERMONT PRECISION TOOLS #651218110 (MODIFIED)	5
1										-91		BASE	O1		4
									B/O	-93	1	BOTTOM CUSHION	Y20, BLACK	2.4 X 10.7 X 15.7 (I.R. SPECIALTIES)	6
									B/O	-95	1	TOP CUSHION	Y20, BLACK	1.47 X 10.7 X 15.7 (I.R. SPECIALTIES)	7
									B/O	-96	1	TAPE	FOAM	.045 X 1 X 22 W/ADHESIVE (MCMMASTER-CARR #75935A23)	N/S
										-97	1	PLACARD	PLASTIC	1/16 X 5 X 7	8
									B/O	-98	1	CASE	PLASTIC	PELICAN CASE #APP-1470	N/S
ASSY -19	ASSY -17	ASSY -15	ASSY -13	ASSY -11	ASSY -9	ASSY -7	ASSY -5	ASSY -3							



**UNDER REVIEW**  
URF 19-691 19.04.18 (MB)

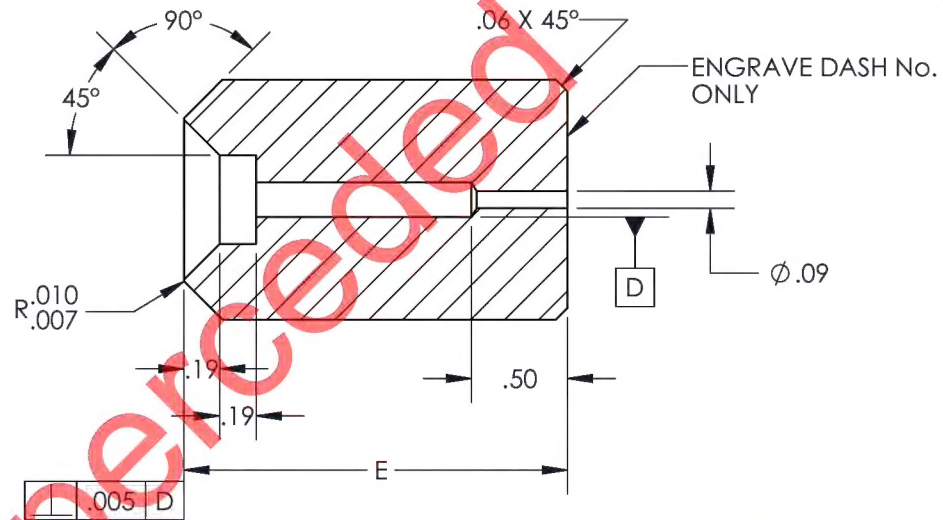
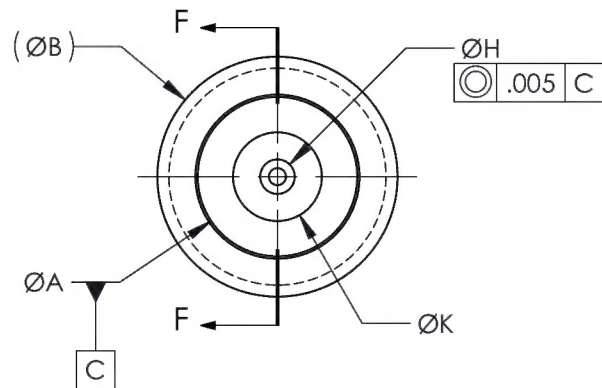
**DART**  
AEROSPACE

RING STAKE TOOL

DWG NO.		RB T101873		REV	1
MAT'L		DRAWN BY: GILBERT			
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		APPROVED <i>D Weil</i>			
.XXX ± .005		HEAT TREAT			
.XX ± .01		FINISH			
.X ± .1		SPEC			
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R		USED ON MODEL			
2. DIMENSIONAL LIMITS APPLY AFTER PLATING					
SCALE 1:8		DATE 5/7/2012		SHEET 2 OF 8	

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
B		-39, -45, -51, -57, -63, -69, -75, -81, -87 ADDED REFERENCE COLUMN K TO TABLE, ADDED DRILL POINT TO HOLE.	9/3/13	CFS	JG
1	14-0210	ADDED DATUM C AND D, ADDED GEOMETRIC TOLERANCE $\perp$ .005 D AND $\odot$ .005 C. DELETED NOTE 2.	11/13/2014	RJC	JAG



SECTION F-F

**UNDER REVIEW**  
URF 19-691 19.04.18 (MB)

**Supercircled**  
#  
PRESS

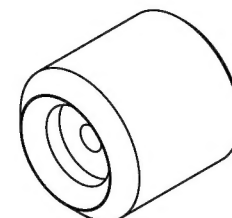
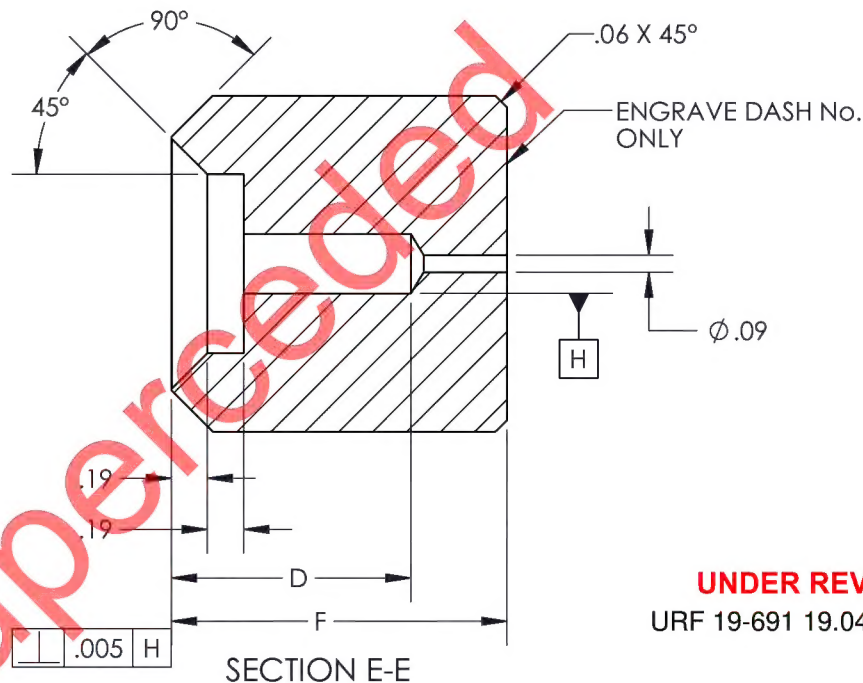
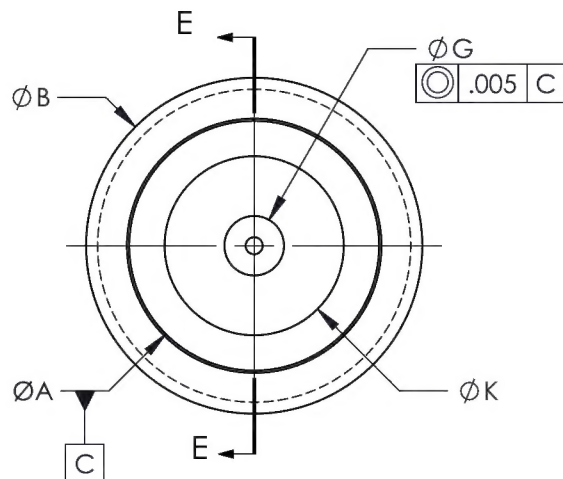
USAGE TABLE

#	A $\pm$ .0025	B	E $\pm$ .030	H $\begin{smallmatrix} +.0008 \\ -.0000 \end{smallmatrix}$	(K)
-39	.8085	1.250	2.25	.2500	.429
-45	.8422	1.250	2.00	.1800	.462
-51	.8752	1.250	2.00	.3125	.495
-57	.9377	1.500	2.25	.3750	.558
-63	.9377	1.500	2.25	.3125	.558
-69	.9692	1.500	2.00	.2500	.589
-75	1.1257	1.500	2.25	.3750	.746
-81	1.1877	1.500	2.75	.5000	.809
-87	1.3127	1.750	2.25	.3125	.933

<b>DART</b> AEROSPACE		
TITLE RING STAKE TOOL		
DWG NO. RB T101873-#	REV 1	
MAT'L 01	DRAWN BY: GILBERT	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	APPROVED <i>D Weil</i>	
.XXX $\pm$ .005	HEAT TREAT HRC 58-62	
.XX $\pm$ .01	FINISH	
.X $\pm$ .1	ANGLES $\pm$ 5°	
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	SPEC	
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	USED ON MODEL	
SCALE 1:1	DATE 5/7/2012	SHEET 3 OF 8

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
A		-43, -49, -55, -61, -67, -73, -79, -85, -91 CH'D TOLERANCE WAS D ±.03 IS D MIN., ADDED REFERENCE COLUMN K TO TABLE, ADDED DRILL POINT TO HOLE.	9/3/13	CFS	JG
1	14-0210	ADDED DATUM C AND E, ADDED GEOMETRIC TOLERANCE $\perp$ .005 E AND $\text{C}$ .005 C. DELETED NOTE 2.	11/13/2014	RJC	JAG



**UNDER REVIEW**  
URF 19-691 19.04.18 (MB)

USAGE TABLE

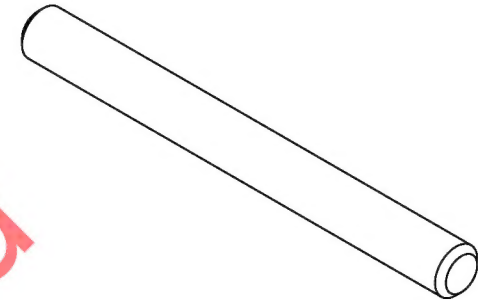
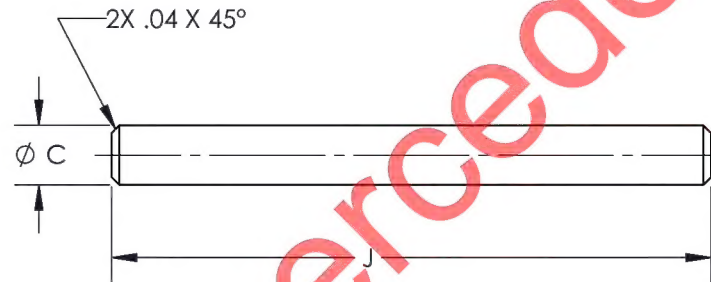
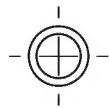
#	A ±.0025	B	D MIN.	F ±.03	G $\begin{smallmatrix} +.0000 \\ -.0008 \end{smallmatrix}$	(K)
-43	.8085	1.250	1.12	1.62	.2478	.429
-49	.8422	1.250	1.00	1.50	.1878	.462
-55	.8752	1.250	1.38	1.88	.3103	.495
-61	.9377	1.500	1.50	2.00	.3728	.558
-67	.9377	1.500	1.50	2.00	.3103	.558
-73	.9692	1.500	1.25	1.75	.2478	.589
-79	1.1257	1.500	1.50	2.00	.3728	.746
-85	1.1877	1.500	2.00	2.50	.4978	.808
-91	1.3127	1.750	1.25	1.75	.3103	.933

<b>DART</b> AEROSPACE		
TITLE RING STAKE TOOL		
DWG NO. RB T101873-#	REV 1	
MAT'L 01	DRAWN BY: GILBERT	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	APPROVED <i>D Weil</i>	
.XXX ± .005	HEAT TREAT HRC 58-62	
.XX ± .01	FINISH	
.X ± .1	ANGLES ± 5°	
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	SPEC	
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	USED ON MODEL	
SCALE 1:1	DATE 5/7/2012	SHEET 4 OF 8



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REVISIONS			
REV	ECR	DESCRIPTION	DATE



(-#)  
GUIDE

**UNDER REVIEW**  
URF 19-691 19.04.18 (MB)

USAGE TABLE

#	C <sup>+0.0010</sup> -0.0000	J
-41	.2480	3.00
-47	.1880	2.62
-53	.3105	3.00
-59	.3730	3.25
-65	.3105	3.88
-71	.2480	3.00
-77	.3730	4.00
-83	.4980	4.38
-89	.3105	3.12

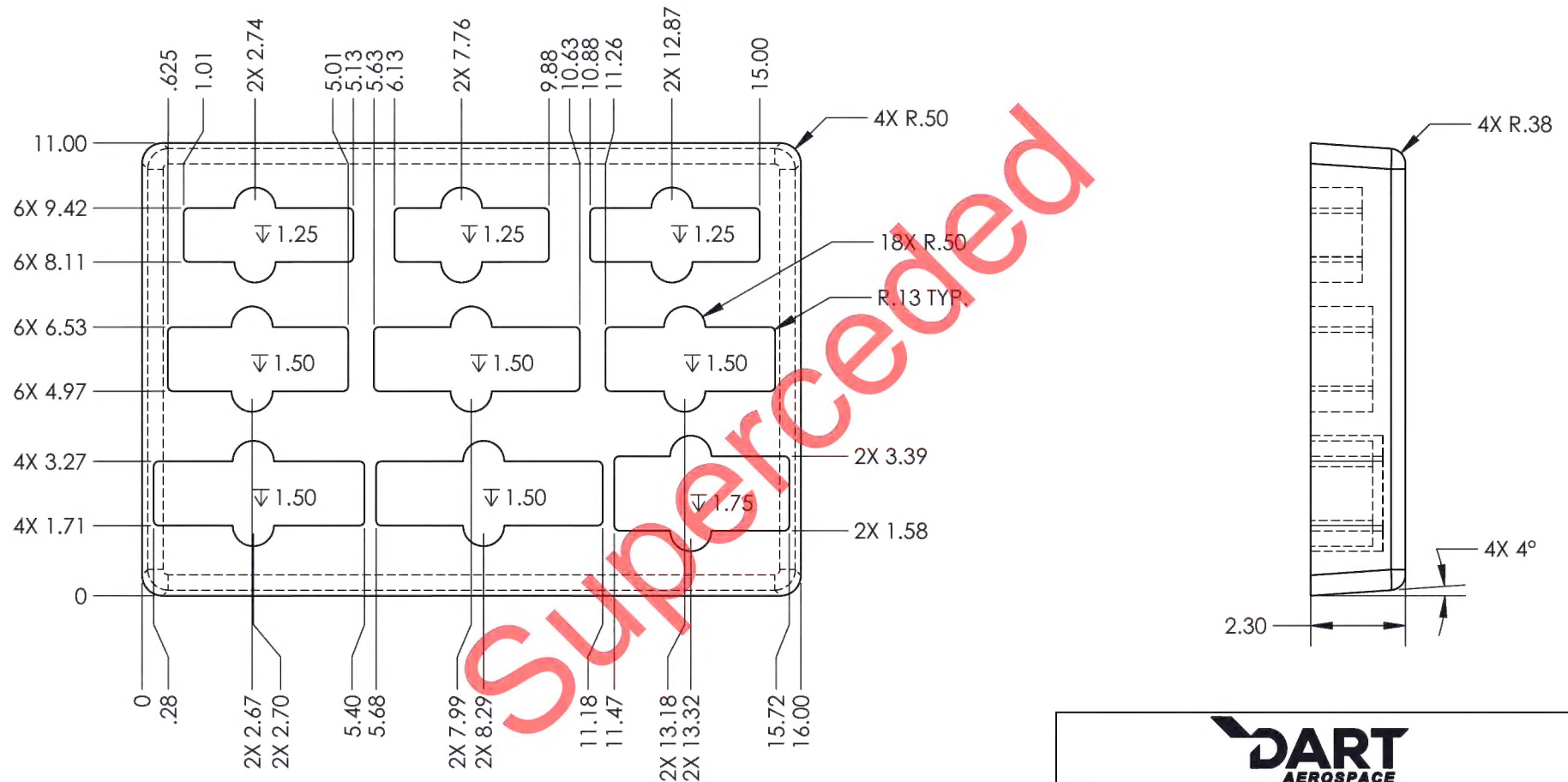


TITLE		RING STAKE TOOL	
DWG NO.		RB T101873-#	
MAT'L		STD HARDENED DOWEL	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		DRAWN BY: GILBERT	
.XXX ± .005		APPROVED <i>D Weil</i>	
.XX ± .01		HEAT TREAT	
.X ± .1		FINISH	
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R		SPEC	
2. DIMENSIONAL LIMITS APPLY AFTER PLATING		USED ON MODEL	
SCALE	1:1	DATE	5/7/2012
		SHEET 5 OF 8	

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1	14-0210	-93 CH'D FOAM WAS FOR MAPLE BOX IS FOR PELICAN CASE #1470. CH'D FOAM WAS GRAY CHARCOAL PLANK IS Y20 BLACK.DESCRPTION	11/6/2014	RJC	JAG

**UNDER REVIEW**  
URF 19-691 19.04.18 (MB)



(-93)

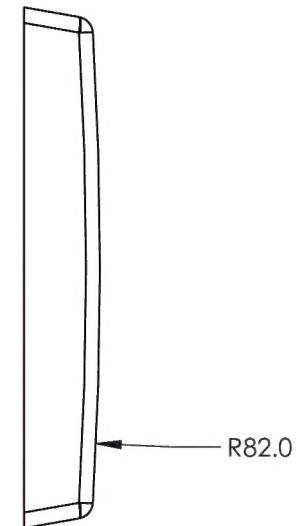
BOTTOM CUSHION

<b>DART</b> AEROSPACE	
TITLE RING STAKE TOOL	
DWG NO. RB T101873-93	REV 1
MAT'L Y20, BLACK	DRAWN BY: CLOUGH
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	APPROVED <i>D Weil</i>
.XXX ± .005	HEAT TREAT
.XX ± .01	FINISH
.X ± .1	SPEC
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	USED ON MODEL
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	BELL
SCALE 1:4	DATE 11/6/2014
SHEET 6 OF 8	

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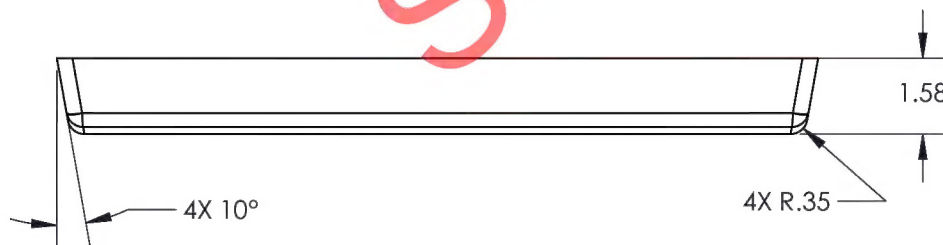
REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1	14-0210	-95 CH'D FOAM WAS FOR MAPLE BOX IS FOR PELICAN CASE #1470. CH'D FOAM WAS GRAY CHARCOAL PLANK IS Y20 BLACK.	11/6/2014	RJC	JAG

4X R.33



**UNDER REVIEW**

URF 19-691 19.04.18 (MB)



(-95)

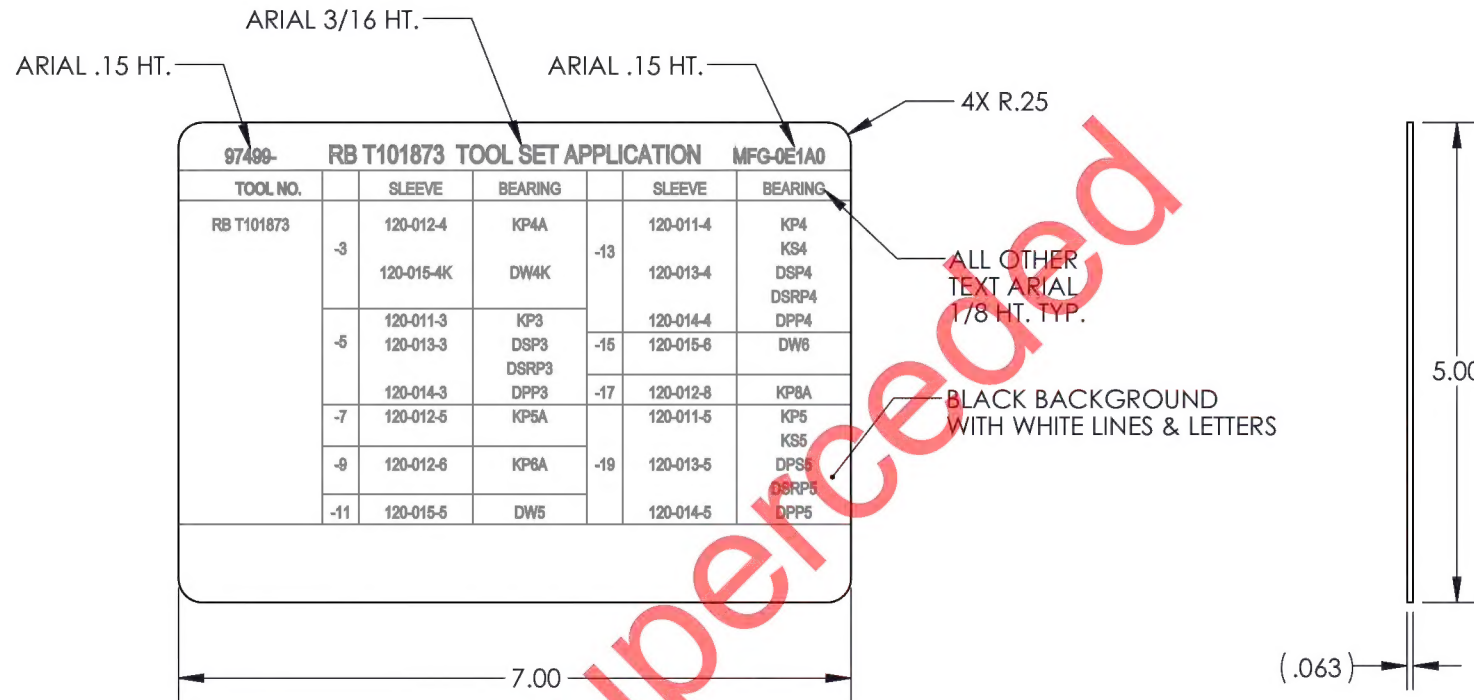
TOP CUSHION

<b>DART</b> AEROSPACE	
TITLE RING STAKE TOOL	
DWG NO. RB T101873-95	REV 1
MAT'L Y20, BLACK	DRAWN BY: CLOUGH
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	APPROVED <i>D Weil</i>
.XXX ± .005	HEAT
.XX ± .01	TREAT
.X ± .1	FINISH
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	SPEC
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	USED ON MODEL
	BELL
SCALE 1:4	DATE 11/6/2014
	SHEET 7 OF 8

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1	14-0210	-97 DELETED 4X Ø.15 HOLES IN CORNERS. CH'D SIZE TO FIT PELICAN CASE.	11/6/2014	RJC	JAG

**UNDER REVIEW**  
URF 19-691 19.04.18 (MB)



NOTE:  
1. USE PDF FILE.  
2. ATTACH PLACARD TO OUTSIDE OF PELICAN CASE LID WITH -96 TAPE AS NEEDED.

(-97)  
PLACARD

<b>DART</b> AEROSPACE	
TITLE RING STAKING TOOL	
DWG NO. RB T101873-97	REV 1
MAT'L PLASTIC	DRAWN BY: GILBERT
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	APPROVED <i>D Weil</i>
.XXX ± .005 FRACTIONS ± 1/8	HEAT TREAT
.XX ± .01 ANGLES ± 5°	FINISH
.X ± .1	SPEC
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	USED ON MODEL
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	BELL
SCALE 1:2	DATE 5/8/2012
SHEET 8 OF 8	